

Date: Friday, 01/08/2008 3:28:48 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING ANGLE
Job Number : 40936	
Estimate Number : 10509	
P.O. Number :	Part Number : D2564
This Issue : 01/08/2008 S.O. No. :	Drawing Number : D2564 REV. B1
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 38026	Material :
Written By :	Due Date : 22/08/2008 Qty: 51 Um: Each
Checked & Approved By : <u>MD 08-8-05</u>	
Comment : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6207	Angle Extrusion
-----	-------	-----------------



Comment: Qty.: 0.0962 f(s)/Unit Total : 4.8090 f(s)
Angle Extrusion
Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
(D6207) Batch: M105462

25 08/08/06 (50)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

28 08/08/06 (50)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
1- Mill as per Folio FA276 Rev: A & Dwg D2564 Rev: B1
2-Deburr if necessary

25 08/08/07 (50)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

25 08/08/07 (50)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

25 08/08/08 (51)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:28:48 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 40936

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5T36

LC 8/8

54

7.0

QC21

FINAL INSPECTION/W/O RELEASE



51

Comment: FINAL INSPECTION/W/O RELEASE

2008/08/11

Job Completion



MF 08-08-08

H:\FORM

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

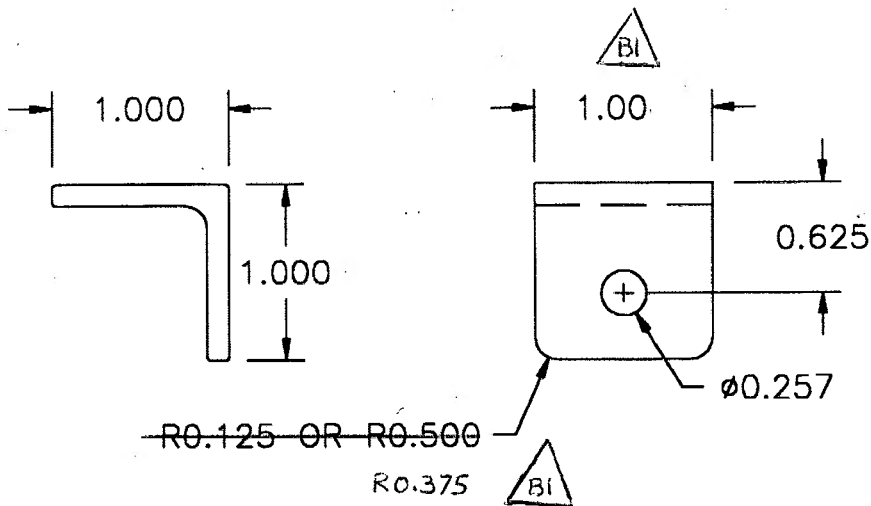
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	MIKE M	DRAWN BY	MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	BW	APPROVED	BW	DRAWING NO. D2564
DATE	96:04:30	TITLE	MOUNTING ANGLE	REV. B SHEET 1 OF 1
B	97:05:06	MODIFIED DIMENSIONS		SCALE 1:1
BI	02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000		

RELEASED
97/05/06 BW**NOTES:**

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI Q18 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40936